

Work Order ID 146983

Tuesday, May 24, 2016 10:39:05 AM

146983

Page 1

Item ID: D3531-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Front Plate
 Start Date: 5/24/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/3/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MC Date: MAY 26 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3531	B								
100	FLOW WATER JET	0.07							
100									
Waterjet	Memo	0.08							
FLOW CNC Waterjet	1-Cut as per Dwg D3531 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.04							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.08							
Quality Control									

PR 06/13/2016

P

PR 06/13/2016

8

DAS
38
JUN 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

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Page 2

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Accept

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Item Name: Bracket Front Plate

Start Date: 5/24/2016 Start Qty: 4.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.00 0.12				DAS 30 9-89	8		JUN 29 2016
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08					(8)		DAS 38 9-89 JUN 29 2016
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.52				8			Oh 16/06/30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Page 3

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170	QC7-Inspect Chemical Conversion Coat	0.00							
-----	--------------------------------------	------	--	--	--	--	--	--	--

170

QC

Memo

0.04

Quality Control

38
9-89

JUL 04 2016

180	Identify as per dwg & Stock Location: _____	0.00							
-----	---	------	--	--	--	--	--	--	--

180

Packaging

Memo

0.04

Packaging

LOCATION : GA

DAS
6
9-89

JUL 04 2016

190	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

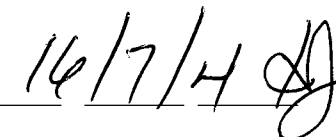
190

QC

Memo

0.40

Quality Control

DAS
21
9-89

JUL 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Tuesday, May 24, 2016 10:39:04 AM

Page 1

Work Order ID: 146983

146983

Parent Item: D3531-3

D3531-3

Parent Item Name: Bracket Front Plate

Start Date: 5/24/2016

Required Date: 6/3/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD
12.10.24 PER DWG REV.B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased		No		100	sf	176.2000	0.1313	0.552842			

M6061T6S 040

6061-T6 .040 Sheet

PR 06/13/2016

Location

Loc Qty

Loc Code

MAT021

176.2

m132037

24.9

m133548

71.3

m134774

80

1.6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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DART AEROSPACE LTD		Work Order:	146983
Description: Bracket Front Plate		Part Number:	D3531-3
Inspection Dwg: D3531 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

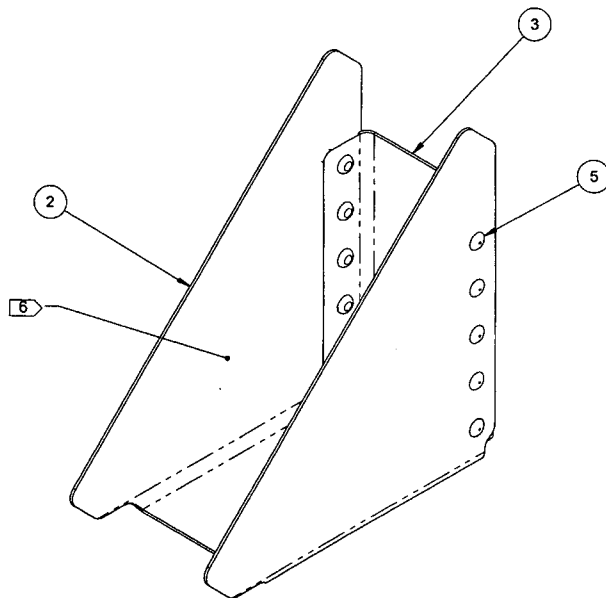
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.132	✓		De-02	
3.72	+/-0.030	3.727	✓			
0.37	+/-0.030	0.369	✓			
2.840	+/-0.010	2.838	✓			
0.88	+/-0.030	0.885	✓			
3.50	+/-0.030	3.500	✓			
4.67	+/-0.030	4.673	✓			

Measured by: PR / ac	Audited by: DAS 38	Preliminary Approval:
Date: 06/13/2016	Date: 9-89	Date:

JUN 15 2016

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	
B	13.07.18	Dwg Rev updated	KJ	

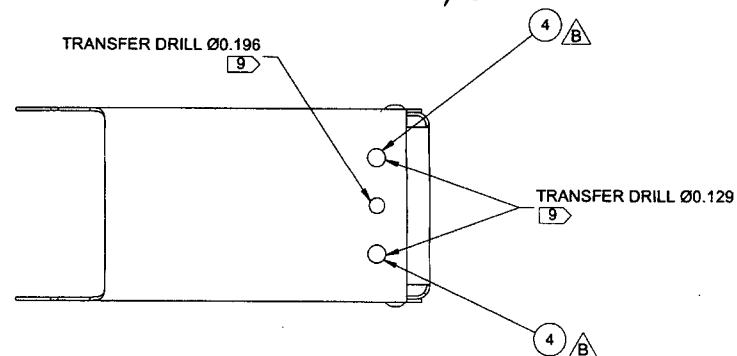
ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3531-041	BRACKET ASSEMBLY
2	1	D3531-1	BRACKET
3	1	D3531-3	BRACKET FRONT PLATE
4	2	MS20426AD4-4	RIVET
5	10	MS20470AD4-4	RIVET



D3531-041 BRACKET ASSEMBLY

NOTES:

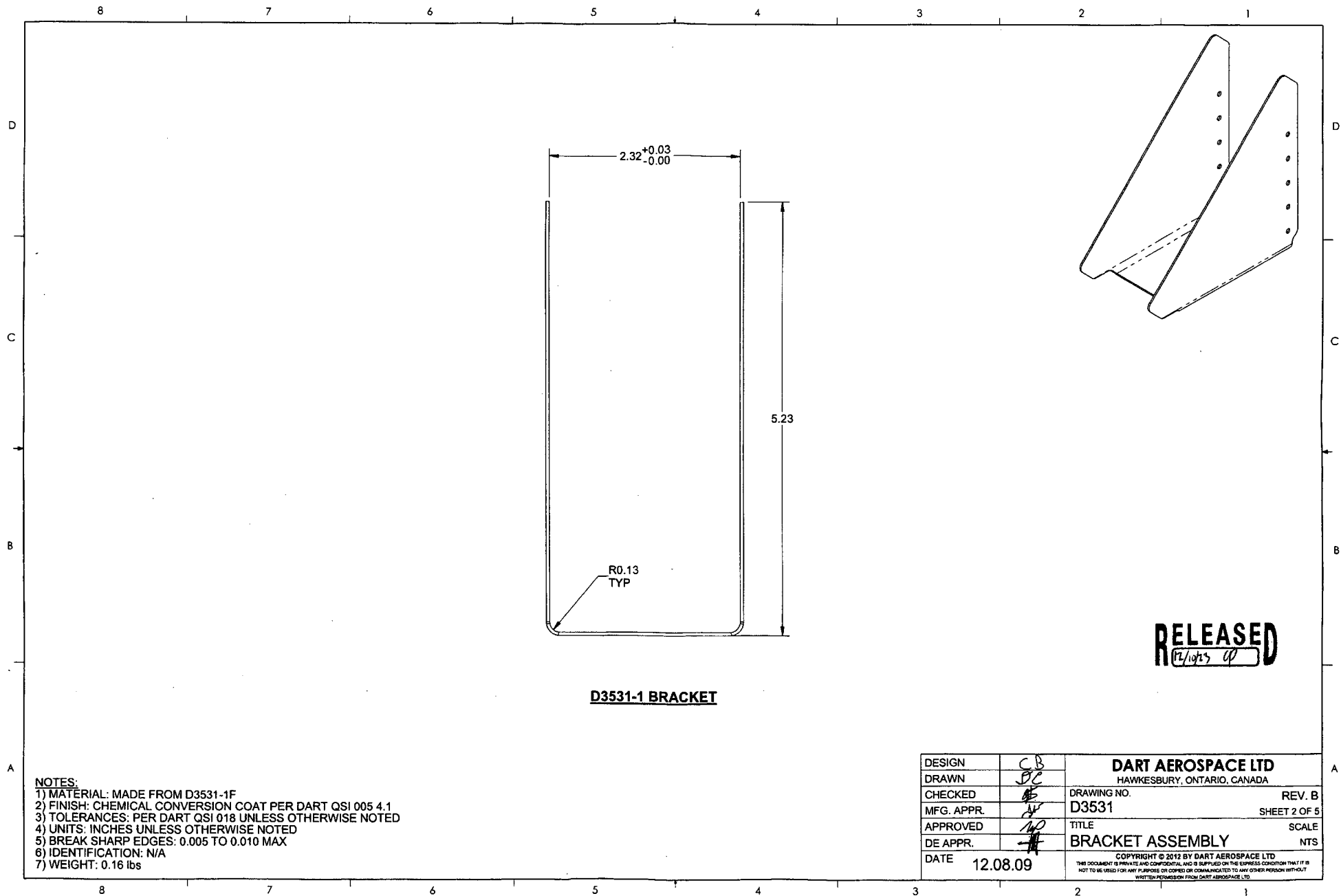
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED
- 7) WEIGHT: 0.22 lbs
- 8) ASSEMBLE PER DART QSI 003
- 9) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING



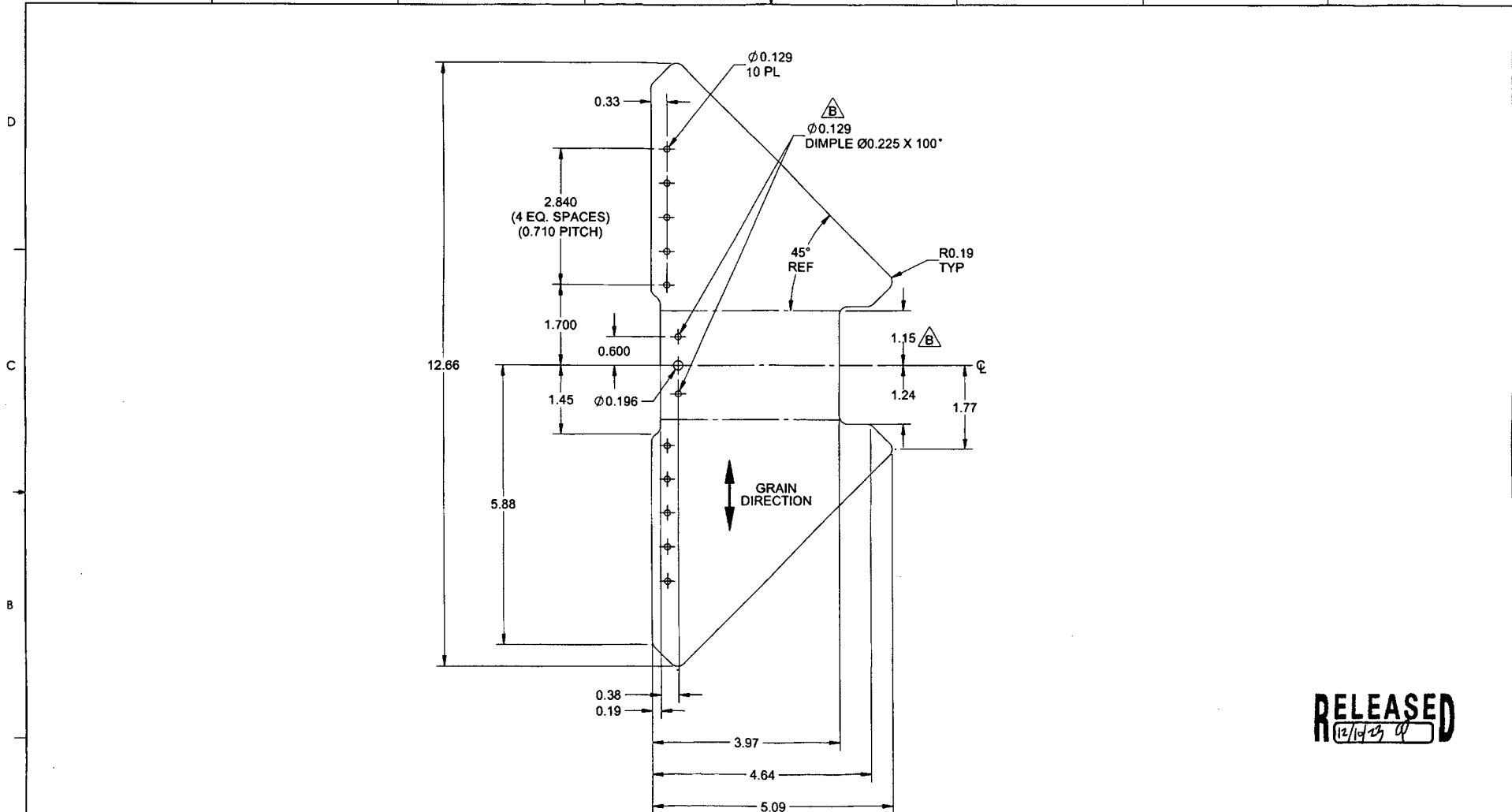
**D3531-041 BRACKET ASSEMBLY
BOTTOM VIEW**

RELEASED
12/10/13 9P
PER ENJ 12-669

B	CHANGE BOTTOM RIVETS FROM MS20470AD4-4 TO MS20426AD4-4, ZN C2-1, C5-3. ADD CSK, ZN C5-3. CORRECT BEND LINE DIM, ZN C4-3. UPDATE TO CURRENT DWG STANDARDS, REF PAR 10-47.	DC	12.08.09
A	NEW ISSUE	CB	07.06.19
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D3531	SHEET 1 OF 5
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	BRACKET ASSEMBLY	NTS
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12/10/15



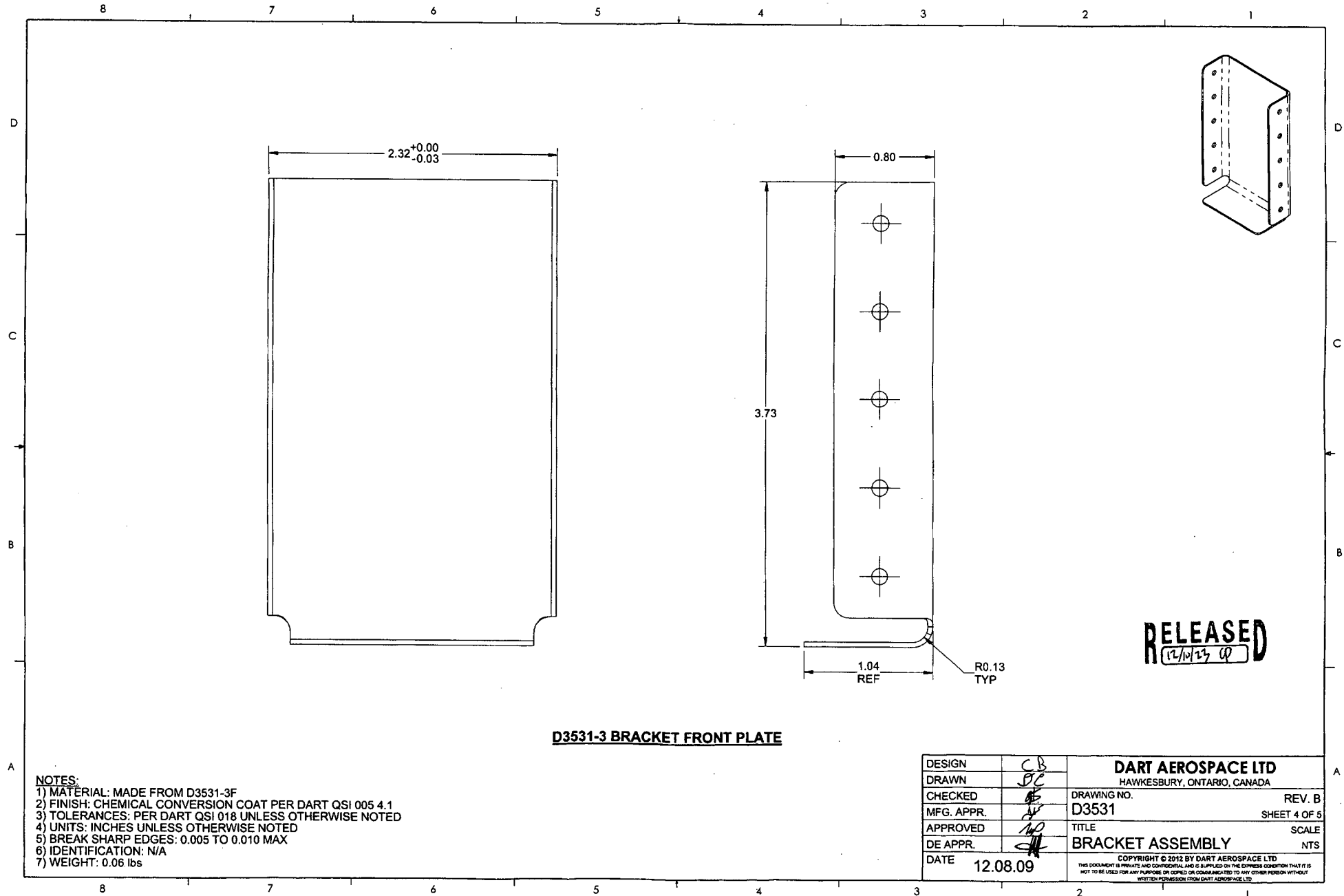
100

D3531-1F FLAT PATTERN

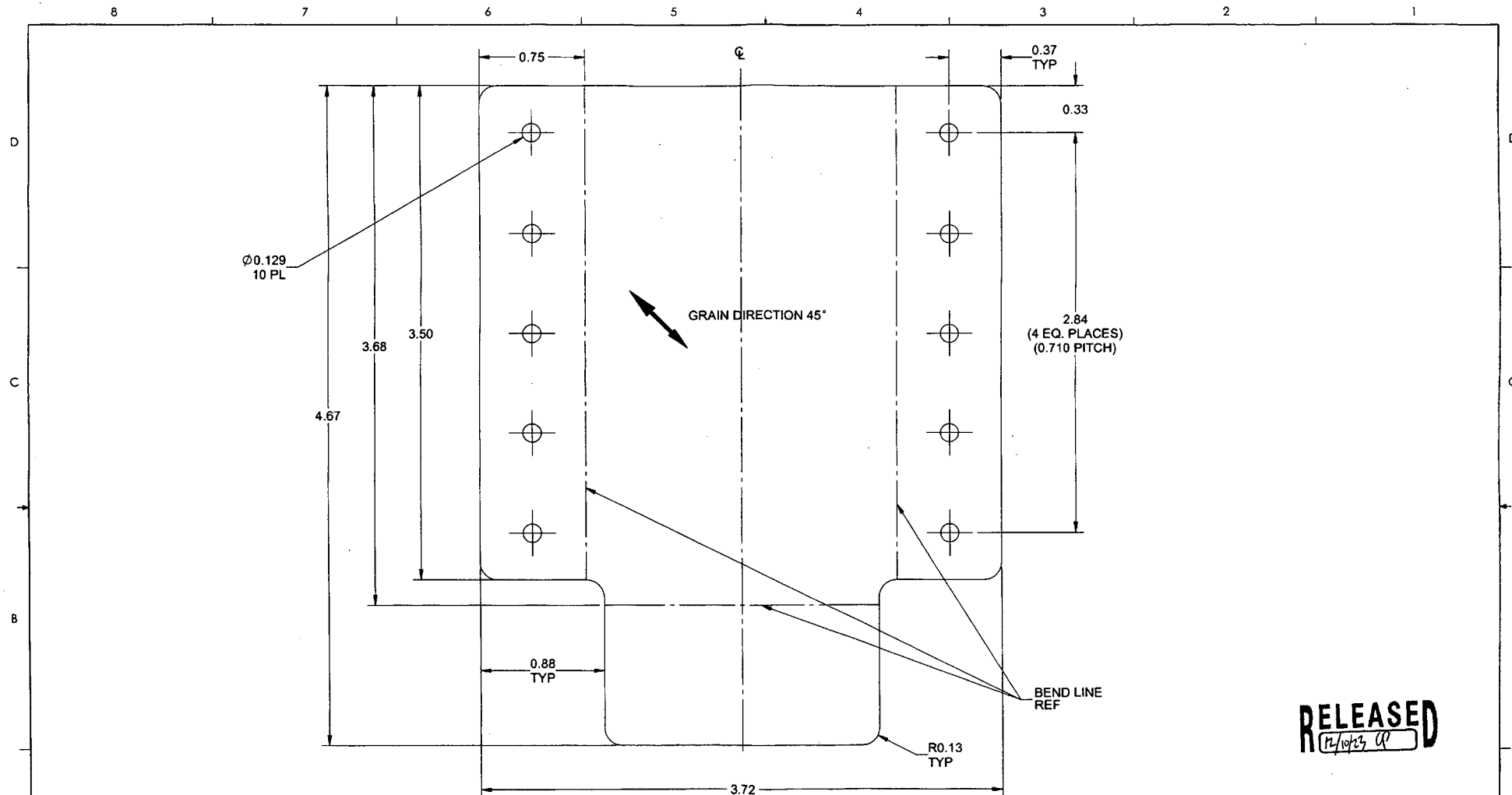
- NOTES:**
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF PART SPEC M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.16 lbs

DESIGN	CB	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BE	DRAWING NO.	REV. B
MFG. APPR.	W	D3531	SHEET 3 OF 5
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D3531-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

DESIGN	CB	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JP	D3531	SHEET 5 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	TH	BRACKET ASSEMBLY	NTS
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